

Work Order ID 48418

June 26, 2009 12:44:09 PM



Page 1

Item ID: D3637-3

Accept



Setup Start



Revision ID: B

Item Name: Bracket

Stop



Start Date: 15/07/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3637

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 1-Dwg Rev: _____ 1-Prod Rev: _____ 2-
Deburr if necessary



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control



120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control



small gap

Work Order ID 48418

June 26, 2009 12:44:09 PM



Page 3

Item ID: D3637-3

Revision ID: B

Item Name: Bracket

Start Date: 15/07/2009 Start Qty: 12.00

Required Date: 03/08/2009 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

— 5026701 (15)

Memo

0.00

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

— MD 09/07/01 (X15)

Memo

0.00

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

BK 09-07-1 (15)

Memo

0.00

Work Order ID 48418

June 26, 2009 12:44:09 PM



Page 4

Item ID: D3637-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bracket

Start Date: 15/07/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: 244A

0.00



Packaging

Memo

0.00

Packaging

9/7/2 SQ



200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/07

MF 09-07-08

Picklist Print

June 26, 2009 12:44:08 PM

Work Order ID: 48418

Parent Item: D3637-3RevB

Parent Item Name: Bracket



Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 12.00

Required Qty: 12.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| ✓ M2024T3S.050  2024-T3 .050 sheet | | Purchased | No | | | 100 | sf | 0.0000 | 1.6926  | | | |

Date: Monday, 08/06/2009 1:12:12 PM
 User: Julie Dawson

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BRACKET |
| Job Number : 48418 | |
| Estimate Number : 12967 | |
| P.O. Number : | Part Number : D36373 |
| This Issue : 08/06/2009 S.O. No. : | Drawing Number : D3637 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : // Type : SMALL /MED FAB | Drawing Revision : B |
| Previous Run : 43184 | Material : |
| Written By : | Due Date : 15/06/2009 Qty: 12 Um: Each |
| Checked & Approved By : <u>Julie Dawson</u> | |
| Comment : Est Rev:A New Issue 07-07-20 JLM Verified By:EC Est Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S050 | 2024-T3 .050 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.1407 sf(s)/Unit Total : 1.6884 sf(s)
 2024-T3 .050 sheet
 Batch: 111381 B 9-6-15

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3637
 Dwg Rev: B
 Prog Rev: B

189-6-15

(15)

2-Deburr if necessary B 9-6-15

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECKS 09/06/15

(40)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 Form as per Dwg D3637

S 09/06/22

(15)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 1:12:12 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 48418

Part Number: D36373

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/06/20 (15)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- drill holes as per dwg using DT8979
2- c'sink holes as per dwg
3-deburr

509/06/23 (15)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/08/01 (15)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9/12/20

(15)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: _____

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|--------------------|
| DART AEROSPACE LTD | | Work Order: | 48418 |
| Description: Bracket | | Part Number: | D3637-3 |
| Inspection Dwg: D3637 Rev: B | | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

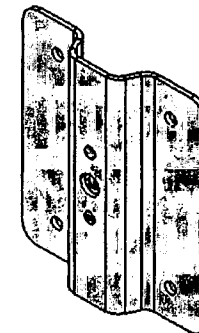
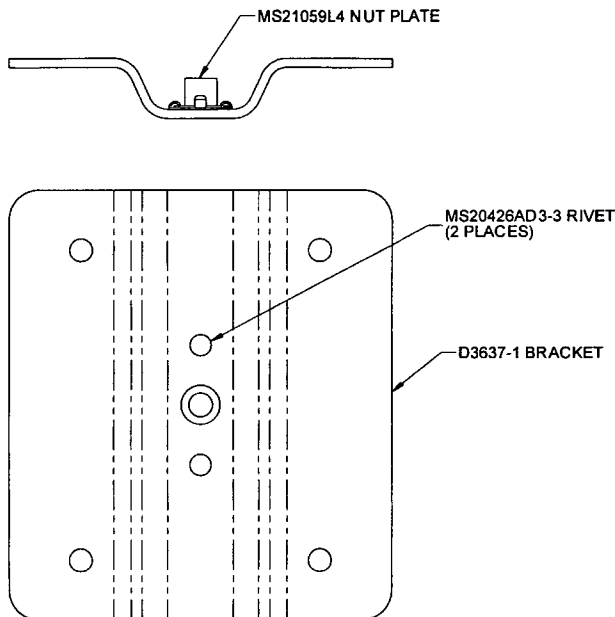
11

Prototype

[illegible]

| | | | |
|----------------|----------------|---------------------|-----|
| Measured by: B | Audited by: S | Prototype Approval: | N/A |
| Date: 9-6-15 | Date: 09/06/15 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 08.12.01 | New Issue | KJ/EC | |



D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

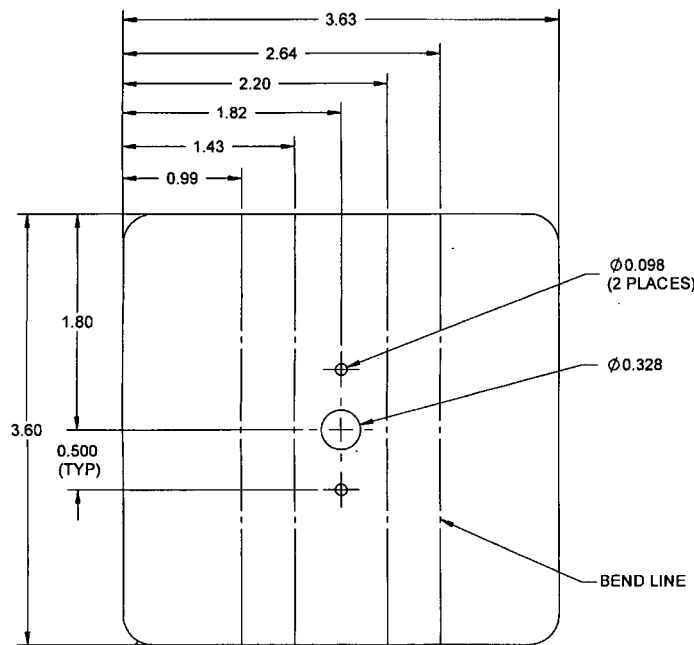
| QTY | P/N | DESCRIPTION |
|-----|--------------|------------------|
| X | D3637-041 | BRACKET ASSEMBLY |
| 1 | D3637-1 | BRACKET |
| 1 | MS21059L4 | NUTPLATE |
| 2 | MS20426AD3-3 | RIVET |

D3637-041 NOTES:

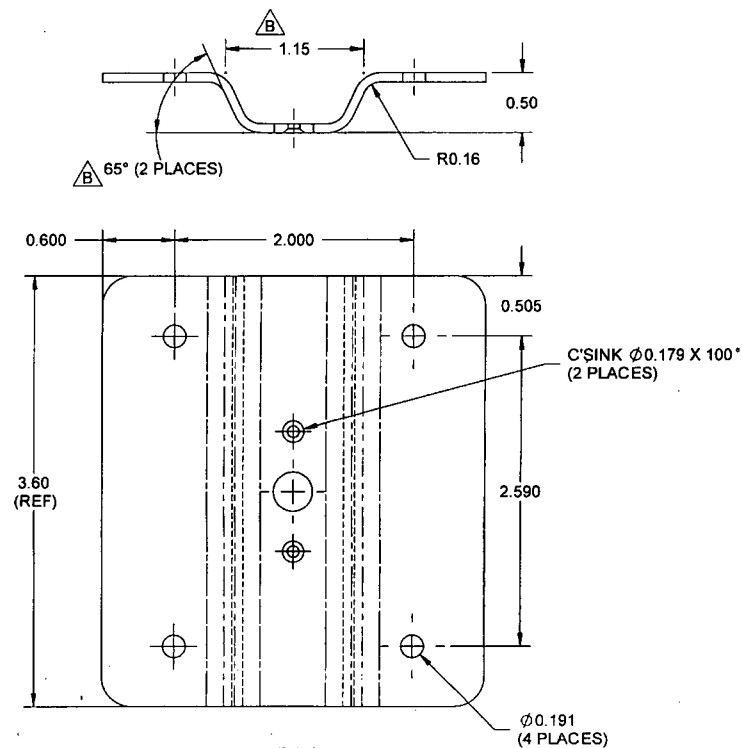
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

NO. 18918
 WORKPIECE
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 RETURN TO
 ENGINEERING
 SHOP COPY

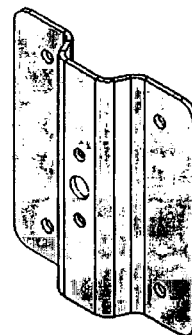
| | | | |
|------------|---|---|--------------|
| B | FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE | LE | 07.12.18 |
| A | NEW ISSUE, REPLACES G10608, G10602 & G10609 | LE | 07.07.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | TS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | LE | | |
| CHECKED | LE | DRAWING NO. | REV. B |
| MFG. APPR. | LE | D3637 | SHEET 1 OF 3 |
| APPROVED | LE | TITLE | SCALE |
| DE APPR. | LE | BRACKET | 1:1 |
| DATE | 07.12.18 | COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |



D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

| | | | |
|----------------------|----|--|-----------|
| DESIGN | TS | DART AEROSPACE LTD | |
| DRAWN | LE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ME | DRAWING NO. D3637 | REV. B |
| MFG. APPR. | ME | SHEET 2 OF 3 | |
| APPROVED | ME | TITLE BRACKET | SCALE 1:1 |
| DE APPR. | ME | COPYRIGHT © 2007 BY DART AEROSPACE LTD | |
| DATE 07.12.18 | | THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

NO. 18
WORK ORDER
WITHOUT NOTICE
ENGINEERING
CONTROLLED COPY
RETURN TO
SHR 0.25
R0.25

| | | | |
|--|----------|-----------------------------|--------------|
| DESIGN | TS | DART AEROSPACE LTD | |
| DRAWN | LE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RET | DRAWING NO. | REV. B |
| MFG. APPR. | EF | D3637 | SHEET 3 OF 3 |
| APPROVED | NY | TITLE | SCALE |
| DE APPR. | ST | BRACKET | 2:3 |
| COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT | | | |
| DATE | 07.12.18 | | |